



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBA9937-5
Job Sheet 182751



Part No: RBA9937-5

Job Qty: 6 ea

Part Name: Tail Rotor Nut Wrench "C" Model (Rb Design)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/24/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBA9937-5 Rev 4 IPP Rev A 18.01.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		9/24/18	0.00	0.00	Start Up Waterjet		DC 18/09/18
110	Waterjet	6 pcs		9/24/18	0.00	0.50	Waterjet 2 OMAX		DC 18/09/18
120	QC	6 pcs		9/24/18	0.00	0.00	QC2 Waterjet-4		DC 18/09/18
130	QC	6 pcs		9/24/18	0.00	0.00	QC8-6		38
150	Outsource	6 pcs		9/24/18			ME1001-VC ATI	10	9-89
160	Outsource	6 pcs		9/24/18			GRO002-VC	10	SEP 21 2018
190	Packaging	6 pcs		9/24/18	0.00	0.00	Packaging2		SEP 21 2018
200	QC	6 pcs		9/24/18	0.00	0.00	QC6		SEP 21 2018
210	Packaging	6 pcs		9/24/18	0.00	0.00	Packaging3-1		SEP 21 2018
220	QC21-SA	6 Ea		9/24/18	0.00	0.00	QC21		SEP 22 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: 4 Prog Rev: 4 (Red Barn folder) 2-Deburr if necessary
 Descriptions: 130 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
 150 - HEAT TREATING 1-Issue P/O to Metcor ; P/O _____ RC 45-47 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech
 160 - -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.188	4130 Sheet .188	.2340 sf (.039 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NS.188	0	4	0

Part Specifications

Specifications could not be found.

Plex 9/6/18 1:19 PM dart.logan.david

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐																																																																																																																																	
Date : _____ St _____	Description Work Container No: S109022 Part: RBA9937-5 Job No: 182751 Serial No/Batch: S109022 Revision: 4 Inspector: _____ Exp Date: _____ Instructions: _____ Date: 09/07/18																																																																																																																																		
		MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																																																	
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER **PO041038**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041038
PO Date: 9/17/18
Due Date: 9/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183070	C10-9-5	Latch Pin 1-Issue P/O to Atlantic; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic to ship directly to Groupe Altech***	Firmed	-	9/21/18	20 pcs	0 pcs	20 pcs	\$3.75/pcs	\$75.00
2	182751	RBA9937-5	Tail Rotor Nut Wrench "C" Model (Rb Design) HEAT TREATING 1-Issue P/O to Atlantic; P/O _____ RC 45-47 2-Bead blast 3-Black Oxide finish 3- Certificate of Conformity is required SHIP TO BACK TO DART	Firmed	-	9/21/18	6 pcs	0 pcs	6 pcs	\$35.75/pcs	\$214.50

Grand Total: \$289.50



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PURCHASE ORDER PO041038

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/21/18 12:51 PM dart.tsimiklis.chrisoula

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 155755
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041038 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
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✓ 6PCS MATERIAL 4140
SAND BLAST AND HEAT TREAT TO 45-47RC
BLACK OXIDE, C OF C, PRT# RBA9937-5, ✓JOB# 182751

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

6

Pounds Shipped:

1.00 DAS
38
9-89

Order No.: 158612

Shipped Complete

Quantity Shipped:

6.00

Received By:

Date:

Pounds Shipped:

1.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 09/19/2018

AB
B-0
47RC
9-20-18

Certification

Date: 09/20/2018

Entry Date: 09/19/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041038

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6PCS MATERIAL 4140 SAND BLAST AND HEAT TREAT TO 45-47RC BLACK OXIDE, C OF C, PRT# RBA9937-5, JOB# 182751	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE	45.	47.	47.	TESTED AS PER SAMPLING PLAN
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HEAT TREATED TO 47 RC AS PER CUSTOMER REQUEST
BLACK OXIDE AS PER CUSTOMER REQUEST

DAS
38
9-89

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD